



Dart Aerospace Ltd.
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Canada

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D4931-3

Job Sheet 185024



Part No: D4931-3

Job Qty: 1 ea

Part Name: Engine Fitting (For B3 Models)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEET 2 IPP REV:A NEW ISSUE 13-09-16 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/2/18	11/2/18	0.00	0.00	Start Up Machining-3		
100	Doosan	4 pcs	11/2/18	11/2/18	0.52	3.96	Doosan		
110	QC	4 pcs	11/2/18	11/2/18	0.00	0.00	QC2 Machining-3		
112	Mill Conv	4 pcs	11/2/18	11/2/18	0.00	1.53	Mill Conv 1		
115	QC	4 pcs	11/2/18	11/2/18	0.00	0.00	QC2 Machining-3		
120	QC	4 pcs	11/2/18	11/2/18	0.00	0.00	QC8 Machining-3		
130	Packaging	4 pcs	11/2/18	11/2/18	0.00	0.00	Packaging3-2	ST 127 DEC 11 2018	
140	QC21-SA	4 Ea	11/2/18	11/2/18	0.00	0.00	QC21		

Part Op 100 - Machine as per folio FB210
Descriptions: 112 - DRILL HOLES AS PER REQUIRED

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	.6000 ft (.15 ea)	90-Start up Operation	SOB010

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R2.000	1	29	0

Part Specifications

Specifications could not be found.

Plex 10/22/18 9:00 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
										QC / QA Coordinator Approval															
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

DART AEROSPACE LTD		Work Order: 185029
Description: EAPS P2 Engine Fitting		Part Number: D4931-3
Inspection Dwg: D4931	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1-1/16-12 UN 2A	Maj: 1.0608 Min: 1.0494	1.058				
M.O.W.	Maj: 1.0995 Min: 1.0938	1.097				Wear .055
0.13 x 45°	+/-0.030 x +/-0.5°	1.8 x 45°				
Ø0.063	+0.004/-0.001	.062				
0.08	+/-0.030	.0795				
0.906	+/-0.010	.908				
0.13	+/-0.030	.125				
0.25	+/-0.030	.2535				
0.938	+/-0.010	.9365				Tolerance are to .005
1.927	+/-0.010	1.931				
0.250	+/-0.010	.25				
0.424	+/-0.010	.428				
0.315	+/-0.010	.315				
0.185	+/-0.010	.187				
37°	+/-0.5°	37°				
0.33	+/-0.030	.335				
34°	+/-0.5°	34°				
0.532	+/-0.010	.532				
1.063	+/-0.010	1.065				
0.594	+/-0.010	.593	✓		Vernier JVO5	
0.791	+/-0.010	.789	✓		Vernier JVO5	
1.188	+/-0.010	1.186	✓		Vernier JVO5	
1.582	+/-0.010	1.585	✓		Vernier JVO5	
Ø.238	+0.005 -0.001	Ø.238	✓		Vernier JVO5	

Measured by: [Signature]	Audited by: [Signature]	Preliminary Approval:
Date: 18/11/28/2005	Date: 18/12/11	Date:

Rev	Date	Change	Revised by	Approved
A	14.06.24	New Issue	KJ	[Signature]

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AEROSPACE

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CANADA
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www.dartaerospace.com

Container No: S132787



Part: D4931-3

Job No: 185024

Serial No/Batch: S132787

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/28/18